Dart Aerospace Ltd. Thursday, 1/25/2007 10:24:46 AM Date: User: Kim Johnston **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : MOUNTING ANGLE **Job Number** : 30464 **Estimate Number** : 10509 :NIA : D2564 Part Number P.O. Number S.O. No. :NIA : D2564 REV. B1 : 1/25/2007 **Drawing Number** This Issue Project Number : N/A Prsht Rev. : NIA : MACHINED PARTS : B1 First Issue Type **Drawing Revision** : MA : 27709 Material **Previous Run** 50 Um: : 2/17/2007 **Due Date** Qty: Written By Checked & Approved By Re-format: Added FA276 Folio KJ/RF Comment **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: Angle Extrusion 1x1x.125 1.0 D6207 Comment: Qty.: 0.0962 f(s)/Unit Total: 4.8090 f(s) Angle Extrusion Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8) J. L 07/02/19 Batch: <u>M27538</u> (D6207) BAND SAW 2.0 Comment: BAND SAW Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030) HAAS CNC VERTICAL MACHINING #1 3.0 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA276 and Dwg D2564 Tumble and Deburr Identify as D2564 4.0 QC2 INSPECT PARTS AS THEY COME OFF Comment: INSPEC PARTS AS THEY COME OFF MACHINE

SECOND CHECK

Comment: SECOND CHECK

QC8

5.0

Page 1

Each

## **Dart Aerospace Ltd**

W/O:		WORK ORDER C	CHANGES	
DATE	STEP	PROCEDURE CHANGE	By Date Qty Approval Chief Eng / Prod Mgr QC Inspector	ai or
		· · · · · · · · · · · · · · · · · · ·		
Part No	:	PAR #: Fault Category:	NCR: Yes No DQA: Date: 17/03/2	_] F

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC	Corrective Action Section B				Corrective Action Section B			Verification	Ammanal	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
						'						

NOTE: Date & initial all entries

Thursday, 1/25/2007 10:24:47 AM Date: Usêr: Kim Johnston **Process Sheet** Drawing Name: MOUNTING ANGLE Customer: CU-DAR001 Dart Helicopters Services Part Number: D2564 Job Number: 30464 Job Number: Description: Seq. #: **Machine Or Operation:** PACKAGING RESOURCE #1 PACKAGING 1 6.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_ FINAL INSPECTION/W/O RELEASE 7.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion 87-027-

Dart Aerospace Ltd	Da	rt	Ae	ro	sp	ac	e l	_td
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W/O:		WORK ORDER C	HANGES	ANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							:		
Part No	:	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	A:	Date:			

QA: N/C Closed: \_\_\_\_ Date: \_

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B		Vification		A		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
				, , , , , , , , , , , , , , , , , , ,					
	Amount of Millians of Phillips								
							,		
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP  Description of NC Section A  Initial Chief Eng Corrective Action Section B  Action Description Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief	STEP Description of NC Section A Initial Chief Eng Chief	STEP Description of NC Section A Section B Section B Section B Section B Section C Sec		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30464
Description: Mounting Angle	Part Number:	D2564
Inspection Dwg: D2564 Rev: B1		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.003				
0.625	+/-0.010	0.625				
Ø0.257	+/-0.010	80.257				
1.000	+/-0.010	1.000				
1.000	+/-0.010	1.001				
R0.375	+/-0.010	RO.3%				
	·					
					100	
					-	

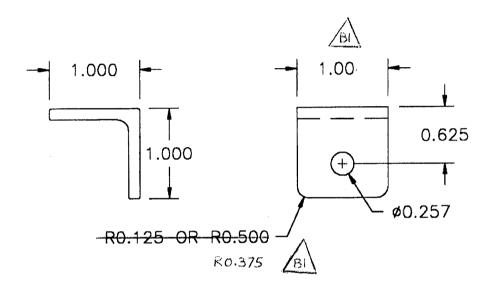
Measured by:	And	Audited by:	J.L		Prototype Approval:	N/A
Date:	07/02/22	Date:	07/02/2	22	Date:	N/A

Rev	Date	Change	Revised by	Approx/ed
Α	04.06.10	New Issue	KJ/JLM	



DESIG		DRAWN BY	DART AEROSPACE LTE victoria international airport, canada			
CHEC		APPROVED	DRAWING NO.	RE	V.	B
B	$\omega$	BW	D2564 SHE	T 1	OF	1
DATE		<u> </u>	TITLE	S	CAL	E
96:0	04:30		MOUNTING ANGLE		1	:1
В		97:05:06	MODIFIED DIMENSIONS			
<u> </u>	1		20376 WAS DO 35 00 00 500			

-	В	97:05:06	MODIFIED DIMENSIONS
	Ві		RO.375 WAS RO.125 OR RO.500 ;
			1,00 WAS 1.000



## NOTES:

MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125

MAKE FROM DE207-XXX ANGLE EXTRUSION

- 2) BREAK ALL SHARP EDGES 0.005 0 015
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE MOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT